

Work Order ID 128214

Tuesday, January 13, 2015 1:22:12 PM

128214

Page 1

Item ID: D3025-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Beam
Start Date: 1/13/2015 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 1/20/2015 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: MCS Date: 15-01-13 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3025	B								
100	FLOW WATER JET	0.00				8	0		Jm 15-1-22
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg								
2024.080"	Dwg Rev: <u>B</u>								
	Prog Rev: <u>B</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00				8	0		Jm 15-1-22
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00				8			
120									
QC	Memo	0.00							
Quality Control									

DAS
38
9-89
JAN 22 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	Bend as per dwg NC BRAKE Memo	0.00 0.00			DAS 30 9-89	8			15/01/23
131 *131* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				8			DAS 38 9-89 JAN 23 2015
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				8		15-3-10 JAN 23 2015	

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							DAS 38 9-89
150									
QC	Memo	0.00							
Quality Control									MAR 10 2015

160	Identify as per dwg & Stock Location <u>SM83</u>	0.00							
160									
Packaging	Memo	0.00							DAS 66 9-89
Packaging									MAR 10 2015

170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									ML5 15-03-11 MF 15-3-10

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Picklist Print

Tuesday, January 13, 2015 1:22:19 PM

Page 1

Work Order ID: 128214

128214

Parent Item: D3025-1

D3025-1

Parent Item Name: Beam

Start Date: 1/13/2015

Required Date: 1/20/2015

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP C01.10.26 Added Bending as per Drawing. SM IPP REV:D
11.05.16 MAT'L THICKNESS CHG DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.080

Purchased

No

100

sf

203.5000

0.75

7

M2024T3S 080

Jm 15-1-22

2024-T3 .080 sheet

Location

Loc Qty

Loc Code

MAT021

203.5

M127668

10.5

M129584

25

M129891

168

129891

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DART AEROSPACE LTD		Work Order:	128214
Description: Beam		Part Number:	D3025-1
Inspection Dwg: D3025 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	0.101"	-		✓	Jkmo
0.25	+/-0.030	0.254"	-		✓	
5.78	+/-0.030	5.78"	-		✓	
3.00	+/-0.030	3.00"	-		✓	
2.395	+/-0.010	2.395"	-		✓	
1.385	+/-0.010	1.385"	-		✓	
0.375	+/-0.010	0.375"	-		✓	
2.332	+/-0.010	2.332"	-		✓	
4.365	+/-0.010	4.365"	-		✓	
4.68	+/-0.030	4.68"	-		✓	
6.92	+/-0.030	6.92"	-		✓	
7.235	+/-0.010	7.235"	-		✓	
9.470	+/-0.010	9.470"	-		✓	Jkmo
10.587	+/-0.010	10.587"	-		✓	
11.705	+/-0.010	11.705"	-		✓	
13.940	+/-0.010	13.940"	-		T	Jkmo
15.057	+/-0.010	15.057"	-		T	
16.175	+/-0.010	16.175"	-		T	
18.75	+/-0.030	18.75"	-		T	
0.080	+/-0.010	0.079"	-		✓	

Measured by: Jm	Audited by: DAS 38 9-89	Preliminary Approval:
Date: 15-1-22	Date: JAN 22 2015	Date:

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue P/O D350-689-013	KJ/JLM	
B	12.07.31	Dimensions updated per Dwg Rev B	KJ	



